

## PATENT ABSTRACTS OF JAPAN

(11)Publication number : 07-244845

(43)Date of publication of application : 19.09.1995

(51)Int.Cl.

G11B 5/84

(21)Application number : 06-034592

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(22)Date of filing : 04.03.1994

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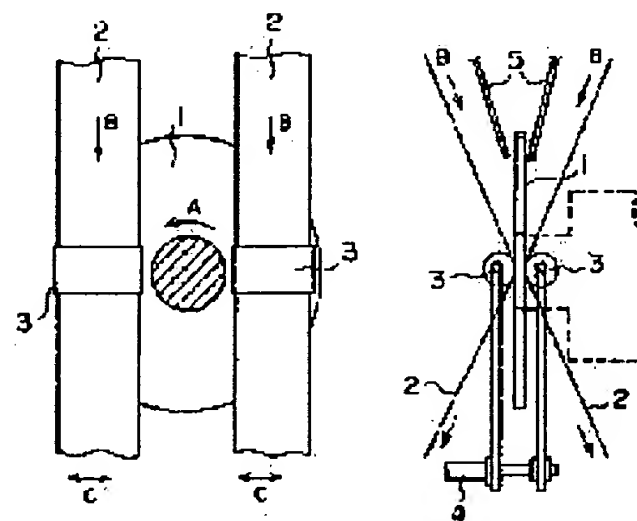
## (54) MANUFACTURE OF MAGNETIC RECORDING MEDIUM

## (57)Abstract:

PURPOSE: To obtain a magnetic disc having excellent characteristics of a head and excellent CSS

characteristics by a method wherein, after a texture process is applied to a substrate surface under specific conditions, a magnetic layer is formed.

CONSTITUTION: A disc-type substrate 1 is made to rotate in the direction of an arrow A. While the substrate 1 rotates, 4 polishing tapes 2 are pressed against both the surfaces of the substrate 1 by contact rollers 3 to polish the substrate 1 surfaces. The roller 3 presses the tape 2 against the surface of the substrate 1 with a fixed force given by a roller pressing cylinder 4. The tape 2 is made to run in the direction of an arrow B under the condition that the circumferential speed at the innermost circumference is not less than 0.25m/sec. and a new tape surface is always brought into contact with the surface of the substrate 1 for polishing. Further, the tapes 2 are made to vibrate in the directions of arrows C by the reciprocal movements of the rollers 3 to polish the whole surfaces of the substrate 1 and so as to have angles  $\theta$  with which polishing tracks A formed on the substrate 1 by the tapes 2 cross each other 10-40°. Further, polishing solution which is the suspension of free polishing grains is supplied to the polishing surface sides of the tapes 2 by nozzles 5. After this texture treatment, protrusions such as burrs and turned-up edges are removed and a metal magnetic thin film is formed by sputtering, etc., to obtain a



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magnetic disc.

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## LEGAL STATUS

[Date of request for examination]

[Date of sending the examiner's decision of rejection]

[Kind of final disposal of application other than the examiner's decision of rejection or application converted registration]

[Date of final disposal for application]

[Patent number]

[Date of registration]

[Number of appeal against examiner's decision of rejection]

[Date of requesting appeal against examiner's decision of rejection]

[Date of extinction of right]

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